

Work Order ID 70259

Thursday, June 02, 2011 9:21:44 AM



Page 1

Item ID: D412-706-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 6/2/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

mk

Date:

11-06-02

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9494

A

IIN-D412-706

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-706-011 CHG003

8

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Purged *U*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70259

Thursday, June 02, 2011 9:21:44 AM



Page 2

Item ID: D412-706-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 6/2/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00 -missing Parts
Per ncn 11-641

QC

Memo

0.00

Quality Control

Sulocelos

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD412-706-011

Location: _____

PPP Rev: _____

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/8 / CK 11/06/03
mf
11-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, June 02, 2011 9:21:39 AM

Work Order ID: 70259



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6D KJ/JLM
 IPP Rev:F 08-05-14 revise comment in seq.17/24 DD verified
 by:EC IPP rev G
 10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23
 as per IIN revA DD verified by:EC IPP Rev:I 10.05.10 as per
 chg003 DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-5A 		Purchased	No			110	Each	1,156.000	4	4			
Bolt													

Location

Loc Qty

Loc Code

ST350

1156

115371

356

117423

800

110

Each

4.0000

1

1

Location

Loc Qty

Loc Code

ST329

4

114742

4

110

Each

15.0000

2

2

Location

Loc Qty

Loc Code

ST329

15

117316

10

117514

5

AN814-6D



Plug

AN815-6D



Union-M-Flare

replace & ship later.

AN814-8D
per NCR 11-641 MRF

M117967 1 KC

115371

117316

6/11/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Page 2

Work Order ID: 70259

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

AN815-8D
Union-M-Flare

Purchased No

110 Each

13.0000

1

1

Location

Loc Qty

Loc Code

ST329

13

113749

3

114544

10

110 Each

16.0000

1

AN832-6D
UNION

Purchased No

Location

Loc Qty

Loc Code

ST333

15

117771

5

117909

10

ST335

1

116289

1

110 Each

10.0000

2

AN833-6D
Elbow, Bulkhead-M-Flare

Purchased No

Location

Loc Qty

Loc Code

ST333

10

117343

10

110 Each

14.0000

1

AN833-8D
ELBOW

Purchased No

Location

Loc Qty

Loc Code

ST333

14

114341

4

114544

10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 70259

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

AN924-6D Purchased No 110 Each 34.0000 4 4
Nut

Location Loc Qty Loc Code

ST335 20

117909 20

ST336 14

117123 14

AN924-8D Purchased No 110 Each 12.0000 1 1
NUT

Location Loc Qty Loc Code

MEZZ 12

114341 4

114544 8

AN938-6D Purchased No 110 Each 14.0000 1 1
Tee

Location Loc Qty Loc Code

ST336 14

101925 14

AN960JD10 NAS1149D0363J Purchased No 110 Each 0.0000 8 8
Washer

AN960JD10L NAS1149D0332J Purchased No 110 Each 0.0000 4 4
Washer

AN960JD916 NAS1149D0363J Purchased No 110 Each 0.0000 2 2
WASHER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 70259

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister



Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2001-4
Valve Assembly (1/4")

Manufactured No

110 Each

8.0000

1

1

Location

Loc Qty

Loc Code

ST002

8

56682

2

68025

6

110 Each

2.0000

1

1

D3262-043
Canister Assembly

Manufactured No

Location

Loc Qty

Loc Code

ST144

2

59738

2

D3264-1
Bracket

Manufactured No

110 Each

11.0000

2

2

Location

Loc Qty

Loc Code

ST144

11

59451

1

68026

10

D3297-1-0098
HOSE ASS'Y

Manufactured No

110 Each

5.0000

1

1

Location

Loc Qty

Loc Code

ST194

5

47500

1

59540

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 70259

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister



Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3297-3-0085 Manufactured No
HOSE ASS'Y



110 Each 5.0000



47801
47301

Location Loc Qty Loc Code

ST194 5
59543 5

D3297-3-0210 Manufactured No
HOSE ASS'Y



110 Each 5.0000



59543

Location Loc Qty Loc Code

ST194 5
47502 1
59544 4

D3298-005 Manufactured No
Tube Assembly



110 Each 14.0000



59544

Location Loc Qty Loc Code

ST195 14
47505 3
48509 5
55527 6

D3298-007 Manufactured No
Tube Assembly



110 Each 9.0000



55527

Location Loc Qty Loc Code

ST195 9
55529 3
58969 6

58969

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 70259

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3299-3

Manufactured No

110

Each

16.0000

1

1



Fitting

Location

Loc Qty

Loc Code

ST046

16

42171

10

55530

6

42171

D3299-5

Manufactured No

110

Each

16.0000

1

1



Fitting

Location

Loc Qty

Loc Code

ST047

16

43657

10

55531

6

43657

D3299-7

Manufactured No

110

Each

10.0000

1

1



Fitting

Location

Loc Qty

Loc Code

ST047

10

57411

10

57411

D3301-1

Manufactured No

110

Each

13.0000

1

1



Placard

Location

Loc Qty

Loc Code

ST047

13

56601

3

56685

10

56685

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Page 6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 70259

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3301-3

Manufactured No

110

Each

11.0000

1

1



Placard



Handwritten signature

Location

Loc Qty

Loc Code

ST047

11

47423

5

60250

6

47423

D3302-1

Manufactured No

110

Each

4.0000

1

1



Doubler



70256

Handwritten signature

Location

Loc Qty

Loc Code

ST143

4

60251

4

D3302-3

Manufactured No

110

Each

6.0000

1

1



Doubler



Handwritten signature

Location

Loc Qty

Loc Code

ST143

6

54578

6

D3329-1

Manufactured No

110

Each

8.0000

2

2



Bushing



54578

B70257

Handwritten signature

Location

Loc Qty

Loc Code

ST048

8

34218

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 8

Work Order ID: 70259

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

S D4054-001

Manufactured No

110

Each

10.0000

1

1



Tube Assembly

Location

Loc Qty

Loc Code

ST193

10

58155

7

58970

3

58155

S D4054-003

Manufactured No

110

Each

10.0000

1

1



Tube Assembly

Location

Loc Qty

Loc Code

ST193

10

58156

6

58971

4

58156

S D4054-009

Manufactured No

110

Each

4.0000

1

1



Tube Assembly

Location

Loc Qty

Loc Code

ST193

4

58157

4

B70258

S MS21042L3

Purchased No

110

Each

2,553.000

4

4



Nut

Location

Loc Qty

Loc Code

ST300

2553

116391

11

116540

76

116549

766

117441

800

117601

400

117885

500

116540

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 70259

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

MS21919-WDG9

Purchased

No

110

Each

51.0000

2

2



Clamp

Location

Loc Qty

Loc Code

ST309

51

107012

3

111578

8

116702

40

111578

MS21920-42

Purchased

No

110

Each

6.0000

2

2



CLAMP(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

ST451

6

117407

6

117407

MS29512-06

Purchased

No

110

Each

3.0000

8



O-RING

87 per NCR 11-641.

Location

Loc Qty

Loc Code

ST294

3

117316

3

117316 94 WU/4/3.

MS29512-08

Purchased

No

110

Each

9.0000

2

2



O-RING

71

Location

Loc Qty

Loc Code

ST294

9

113706

9

113706

PJO
→

W/O: 70259		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		NCR 11-641 ADD MS 29512-08x 1 per Kit B <u>M113706</u> ADD AN814-8D x1 Per Kit. We will ship out. to customer of once we receive it. NCR 11-641.	MR			1106.03	

Part No: D412-706-D11 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Thursday, June 02, 2011 9:21:41 AM

Work Order ID: 70259



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

MS35489-11

Purchased

No

110

Each

14.0000

1

1



GROMMET

6/2/11 (1)

Location

Loc Qty

Loc Code

ST296

14

109166

14

109166

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-706 REV. A AND ICA-D412-706 REV. 0

REF TCCA STC: SH04-54
REF FAA STC: SR02055NY
REF. EASA STC: EASA.IM.R.S.01180

REFERENCE ONLY

DESCRIPTION:

AT CHG 002, THE D412-706-011 FUEL PURGE CANISTER INSTALLATION HAS BEEN MODIFIED WITH LARGER VENT LINES TO ELIMINATE BACK PRESSURE THAT MAY OCCUR WHEN STARTING THE SECOND ENGINE IF THE CANISTER HAS NOT BEEN PROPERLY DRAINED. THE BACK PRESSURE IS EVIDENCED BY AN ONGOING VAPOR DISCHARGE FROM THE CANISTER VENT AT LOW TO MEDIUM RPM WHILE STARTING THE 2nd ENGINE. THE UPDATED PARTS LIST IS SHOWN BELOW:

IS




QTY -011	PART NUMBER	DESCRIPTION
X	D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
1	D2001-4	VALVE ASSEMBLY
1	D3262-043	CANISTER ASSEMBLY (WAS D3262-041)
2	D3264-1	BRACKET
1	D3297-1-0098	HOSE ASSEMBLY
1	D3297-3-0085	HOSE ASSEMBLY
1	D3297-3-0210	HOSE ASSEMBLY
1	D4054-001	TUBE ASSEMBLY (WAS D3298-001)
1	D4054-003	TUBE ASSEMBLY (WAS D3298-003)
1	D3298-005	TUBE ASSEMBLY
1	D3298-007	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY (WAS D3298-009)
1	D3299-7	FITTING (WAS 3299-1)
1	D3299-3	FITTING
1	D3299-5	FITTING
1	D3301-1	PLACARD
1	D3301-3	PLACARD
1	D3302-1	DOUBLER
1	D3302-3	DOUBLER
2	D3329-1	BUSHING
4	AN3-5A	BOLT
1	AN814-6D	PLUG
2	AN815-6D	UNION
1	AN815-8D	UNION (WAS AN815-6D)
1	AN832-6D	UNION
1	AN833-6D	ELBOW
1	AN833-8D	ELBOW (WAS AN833-6D)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.01.07
CERT. NO.: SH04-54
ISSUE NO.: 1

A	NEW ISSUE	RF	10.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	MA	DSI 9494	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		212/412 CANISTER UPGRADE KIT	NTS
DATE	10.01.07	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

REFERENCE ONLY

Continue from previous sheet

4	AN924-6D	NUT
1	AN924-8D	NUT (WAS AN924-6D)
1	AN938-6D	TEE
4	AN960JD10L	WASHER (OR NAS1149D0332J)
8	AN960JD10	WASHER (OR NAS1149D0363J)
2	AN960JD916	WASHER
4	MS21042L3	NUT
2	MS21919WDG9	CLAMP
2	MS21920-42	CLAMP
8	MS29512-06	O-RING (WAS MS28778-6)
2	MS29512-08	O-RING (WAS MS28778-6)
1	MS35489-11	GROMMET

FOR CUSTOMERS WHO HAVE EXPERIENCED THIS PROBLEM IN SERVICE, THE DSI 9494-011 UPGRADE KIT IS AVAILABLE TO UPGRADE THE INSTALLATION FROM CHG 001 TO CHG 002.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9494-011	212/412 CANISTER UPGRADE KIT
1	D3262-043	CANISTER ASSEMBLY
1	D4054-001	TUBE ASSEMBLY
1	D4054-003	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY
1	D3299-7	FITTING
1	AN815-8D	UNION
1	AN833-8D	ELBOW
1	AN924-8D	NUT
2	MS29512-08	O-RING




WEIGHT AND BALANCE:
NO CHANGE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.01.07
CERT. NO.: SH04-54
ISSUE NO.: 1

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9494	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		212/412 CANISTER UPGRADE KIT	NTS
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